

Work Order ID 63297

Wednesday, October 27, 2010 10:50:10 AM



Page 1

Item ID: D212-725-1-059

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: ALDate: 10-10-27 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

F

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: FProg Rev: F

2-Deburr if necessary

10-10-28

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo * See Attached email per holes missing *	0.00 0.00							
						②			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
						2			BL 10-10-28
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
						27			10/10/28 7 0

W/O:		WORK ORDER CHANGES					
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Page 3

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Stop

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Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 383

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 10:50:14 AM

Page 1

Work Order ID: 63297



Parent Item: D212-725-1-059



Parent Item Name: Bracket

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	89.0000	0.0364	0.076632			



MS 10-10-08

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT22

89

113866

8.5

114351

80.5

113866

(2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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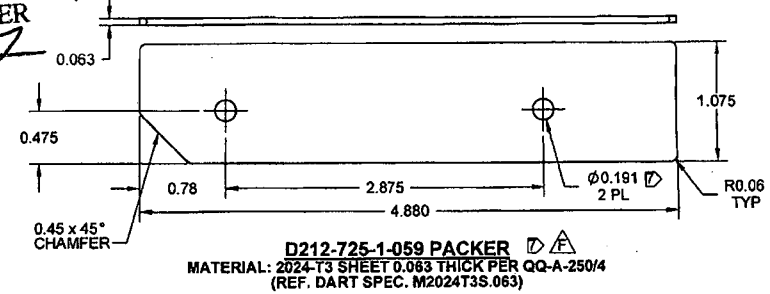
D212-705-1-059

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Measured by:	LB	Audited by:	S	Prototype Approval:	
Date:	10-10-28	Date:	10/10/28	Date:	

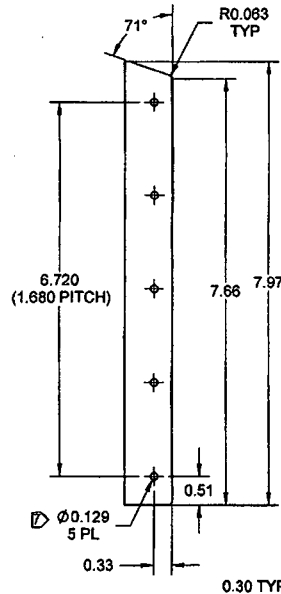
H:\FORMS\Quality Assurance\approved QA\FAI revD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 03297

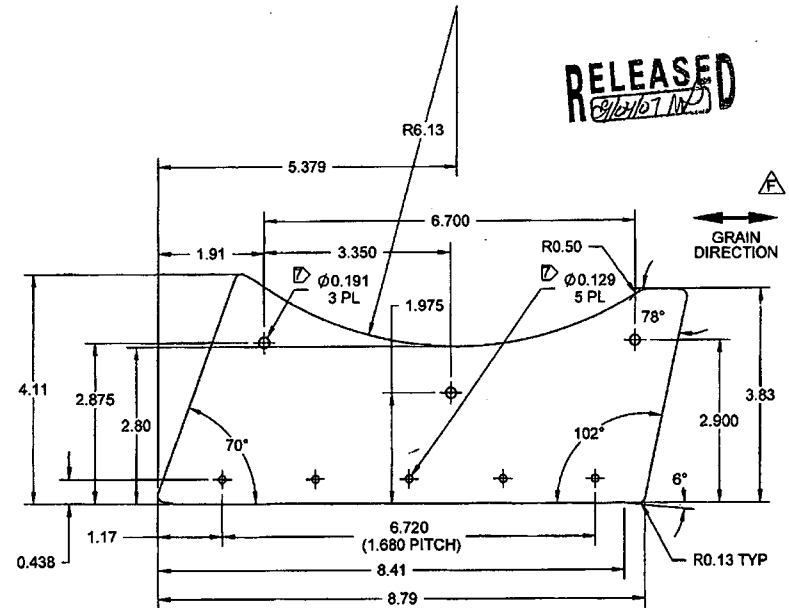


RELEASED
3/6/07

D212-725-1-055 ANGLE
MATERIAL: 2024-T3511 (QQ-A-200/3F) ANGLE EXTRUSION
(REF. DART SPEC. M2024T3-A)






D212-725-1-057F FLAT PATTERN
MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4
(REF. DART SPEC. M2024T3S.060)



D212-725-1-057F FLAT PATTERN

GENERAL NOTES:

- 1) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT IN ACCORDANCE WITH AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: N/A
- 7) DIMENSIONS BETWEEN HOLES ARE PROVIDED FOR REFERENCE ONLY, TRANSFER 0.129, 0.191 HOLES FROM AIRCRAFT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 24 OF 84
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.02.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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L Lacelle

From: Robert Fuentes [rfuentes@dartaero.com]

Sent: October 27, 2010 1:03 PM

To: 'L Lacelle';

Cc: 'H. Siemens'; 'David Shepherd'

Subject: RE:

That be ok Linda, send that part as is, If they have problem I correct that when we release D-4 digits number.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: Wednesday, October 27, 2010 9:47 AM

To: 'Robert Fuentes'

Cc: 'H. Siemens'; 'David Shepherd'

Subject: FW:

Roberto,

I have had these cut already to the dxf's you supplied, I can charge Eagle for the scrap parts, or you take them as is...what is your preference?

Please next time let someone know that the dwg or dxf is changed, we NEVER receive an ECN for the change in these parts, so no one knows about it!

LL

From: David Duval [mailto:dduval@dartaero.com]

Sent: October 27, 2010 11:43 AM

To: Linda Lacelle

Subject:

d212-725-1-123 do we cut it or what

[11:31:31 AM] David Duval: the rad is at 4.00"

[11:34:53 AM] Roberto Fuentes: the new radius is 3.75" from same center as old

[11:36:13 AM] David Duval: send me the new dxf with the new dwg

[11:41:32 AM] Roberto Fuentes: ok, I will send to replace old file that you have.

[11:42:22 AM] David Duval: plus the dxf you sent me is missing the 2 bottom hole .25"

David Duval

Production Engineering Coordinator



1270 Aberdeen Street

Hawkesbury Ontario

Canada K6A 1K7

Tel: (613) 632-5200

dduval@dartaero.com



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10/27/10